

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007903**Date Inspected:** 16-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Peng Guo.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, South Tower, Strut Plates.

SMAW welding of weld joint SD1-A5002-25-1B & SD1-A5002-26-1B & SD1-A5002-27-1B & SD1-A5002-28-1B; located on Bay11, South Tower. Welder is identified as 058009, 040656; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3211-TC-U5B-1.

Bay11, Lift 4, Skin E, West Tower.

SAW welding of weld joint WSD1-FESA4-4A/F-7A, 9A; located on Bay11, Lift 4, Skin E, West Tower. Welder is identified as Yang Meizhen 042195; ZPMC Quality Control Inspector (QC) is identified as Peng Guo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2221-B-U3C-S-2.

Bay11, East Tower, Internal Splice Plate.

FCAW welding of weld joint ESD1-SPSA3-56-1B, 2B; located on Bay11, East Tower. Welder is identified as 055792, 046706; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

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Bay11, East Tower, Internal Splice Plate.

FCAW welding of weld joint ESD1-SPSA3-67-1B, 3B; located on Bay11, East Tower. Welder is identified as 202821, 040713; ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U5-F.

Bay11, Lift 2, West Tower, BC & CD Corner Seams (Inside).

ZPMC preparing for REPAIR welding of weld joint WSD1-TL6J/L58, 57, 55, 56; located on Bay11, Lift 2, West Tower, BC & CD Corner Seams (Inside); ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. WPS: WPS-345-SMAW-2G(2F)-REPAIR, WPS-345-SMAW-3G(3F)-REPAIR.

Bay11, Lift 2, West Tower, AB Corner Seam (Inside).

ZPMC preparing for REPAIR welding of weld joint WSD1-TL6B/L-5B; located on Bay11, Lift 2, West Tower, AB Corner Seam (Inside); ZPMC Quality Control Inspector (QC) is identified as Xu Le Feng. The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

Inspected By: Juvekar,Amit

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer